

ABSTRACT

An insert for a combustion head gasket seals a coolant or oil aperture. The insert is manufactured separately from the main gasket structure, and is formed of two materials, a metallic body and an elastomeric sealing bead bonded thereto. A

5 disclosed method for manufacturing the insert includes shaping the insert body and molding the bead in a single process. The method includes the steps of: (a) providing a mold having an upper section and a lower section, the lower section defining a cavity adapted to receive a blank metal substrate; (b) placing the metal substrate into the mold cavity; (c) closing the upper section against the substrate to hold the insert in  
10 place under a first applied force; (d) applying a second force greater than the first to shape the insert; (e) supplying elastomeric material to predetermined selected portions of the blank metal substrate; and (f) curing the elastomeric material.

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